

Date: Thursday, 23/04/2009 1:55:04 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	EXTRUSION 'I' BEAM
Job Number :	47408		
Estimate Number :	13878		
P.O. Number :		Part Number :	D38821130
This Issue :	23/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3882 PREL
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	PREL
Written By :		Material :	
Checked & Approved By :	<u>C209/04/23</u>	Due Date :	23/04/2009
Comment :	Est Rev:A New Issue 09-04-23 JLM Verified By:EC		

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 8219C209/04/23

a) Extrude as per Dwg D3882

b) Material: 6061-T6 (QQ-A-200/8) OR ASTM B221

(9)

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 130" long

g) Bon L Canada Inc. tool #DAA-6

H Pull test to ASTM standard B221 required.

J) Material certification is required

2.0

D38821130P

I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)
 I Beam

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg ~~D3880~~ D3882Check Pull test per Dwg ~~D3880~~ for compliance page attached.

Check hardness with Webster tester

9/3/2 (9)
 09.04.27
 AU OK

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 1:55:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION "I" BEAM

Job Number: 47408

Part Number: D38821130

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Lg.

C 209/04/28 (9)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/09/02

Job Completion



MF
09-04-28

POSITIVE RECALL

EFFECTIVE 09.04.24 AUTH U

RELEASED U DATE 09.04.28

MP 09/09/02

Dart Aerospace Ltd

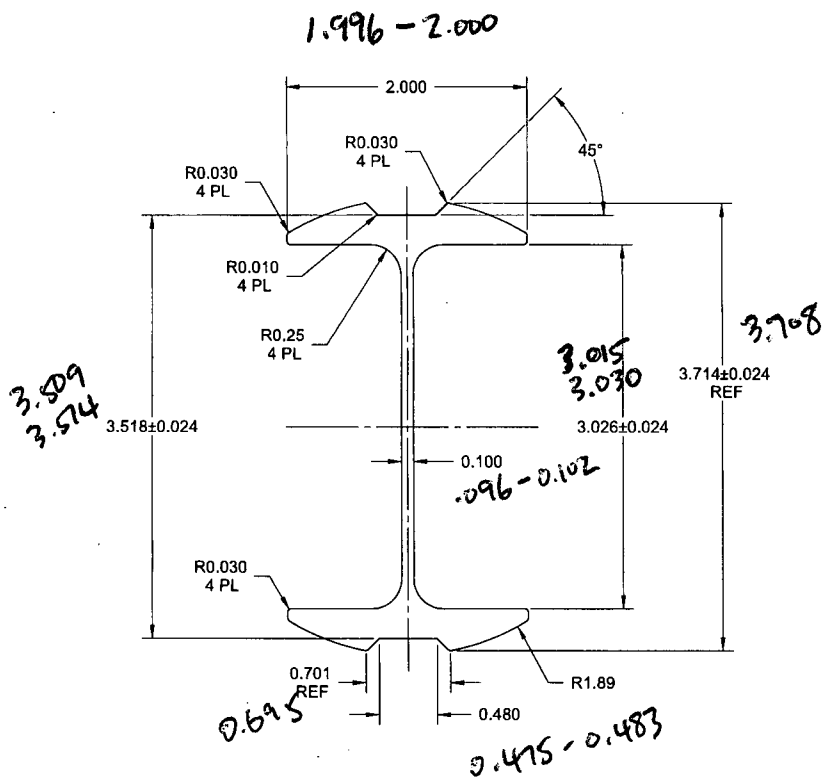
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



GENERAL NOTES:

1) MATERIAL: 6061-T6 PER QQ-A-200/8 OR ASTM B221
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES

2) BREAK ALL SHARP CORNERS 0.010 MAX

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) PART NUMBER IS D3882-1-XXX WHERE XXX IS
 CUT LENGTH IN INCHES (EX. D3882-1-180 IS 180" LONG)

6) D3882-1 EXTRUSION MANUFACTURED FROM: DIE # DAA-6

PRELIMINARY

09-04-23

Reference only

D3882-1 EXTRUSION

WEBSTER = 16 to 17
 CHECKED FIT WITH D2500-1 OK

A	NEW ISSUE	RF	09.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	GP		
MFG. APPR.	NS		
APPROVED	HP		
DE APPR.	HT		
DATE	09.01.23		
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Receiving Report

Date:

9/3/17

Batch No:

11/1202

Supplier:

SIGNATURE

Dart P/O:

8219

Packing Slip:

Yes

✓

No

Invoice:

Yes

✓

No

Receipt:

Cash

✓

Cr

Release Note Attached:

Yes

✓

No

Waybill Attached:

Yes

✓

No

Shipment Complete:

Yes

✓

No

Q66 Inspection

✓

N/A

Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

Location

H:\FORMS\Purchasing\approved purchase\REPORT - Rev D

CING COMPANY AND LOCATION
ATURE ALUMINUM CANADA
EDWARD AVENUE
MOND HIL ON L4C 4Y9

TERMS / FREIGHT

O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP
HAMBROOK, PAU
905-508-3250

SHIPPING MANIFEST
MANIFEST DATE
03-16-09
MANIFEST NUMBER
656298
SALES ORDER NUMBER
44010

SALES REP

TRAILER NUMBER
57392

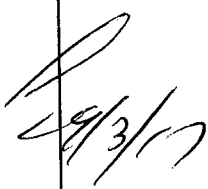
SALESMAN
59358

FIELD SALES REP
Kutter A
450-435-6551

CUST SERVICE REP
Burton D
905-427-2227

EXPORT

BILL OF LADING NUMBER
08390020

FINISH DESCRIPTION		THIS SHIPMENT			UNIT	QUANTITY DUE
FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY			
SHIPPING TOLERANCE						
MILL CERTIFICATE OF COMP (+015-015,0011-0008)		1	165	152 97.50 9	LB FT PC	0 0 0
THIS NEW DIE - PLEASE ENSURE ALL ERANCES. PLEASE PROVIDE A 6-PART						
44010010 / 206326		1	165	152		9 PC
						
d dated below		1	165	152	LB	
PAGE 1				97.50	FT	
roduced in rse side.				9	PC	
		TOTALS				

d dated below

PAGE

1

roduced in
rse side.

DATE OF DELIVERY

DRIVER

**Purchase Order**

Date Feb 18, 2009	Page 1
Purchase Order Number PO00008219	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Signature Aluminum
1850 Clements Road
Pickering, ON L1W 3R8
Phone (800) 563-1079
Fax (800) 565-8339

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-BON001	PO Date Feb 18, 2009	Terms N30	Ship Via yours	Expected Arrival Mar 20, 2009
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
1.0000	TOOLING ✓	SERVICE CHARGE	20/03/2009	No	1.040.000000		1.040.00
		Comments: SERVICE TOOLING CHARGE P/N DAA-6					
9.0000	D38821130P ✓	1 Beam	20/03/2009	No	44.980000	Each	404.82
		Comments: MATERIAL: 6061-T6					
		DIE: # DAA-6					
		SIZE: 130" LONG					
		SAMPLE RUN OF 9 PIECES					
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
Comments:		Tax Summary:		Less:			
		GST		72.24		included tax	
		GSTME		0.00			
		GSTND		0.00			
		Entered By: CL CLAVOIE		Subtotal		1,444.82	
		Approved By:		Total tax		72.24	
				Total purchase order in			
				CAD Dollars		1,517.06	



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

TERMS / FREIGHT
O / P

REFER TO THESE NUMBERS ON ALL CORRESPONDENCE	MANIFEST DATE 03-16-09
	MANIFEST NUMBER 656298
	SALES ORDER NUMBER 44010
CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227
BILL OF LADING NUMBER 08390020	

CUSTOMER ID 46024	ORDER DATE 02/19/09	CUSTOMER PO NUMBER 8219
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JOB DIM. REPORT

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER LENGTH CUTTING TOLERANCE	FINISH DESCRIPTION FABRICATION DESCRIPTION SHIPPING TOLERANCE	THIS SHIPMENT			UNIT	QUANTITY DUE
							NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	175	LB	0	DAA-6-1	6061 /T6	MILL	1	165	152	LB	0
	108	FT	0	D3882-1	130"	CERTIFICATE OF COMP			97.50	FT	0
	10	PC	0		+3/16 " -0 "	(+015-015,0011-0008)			9	PC	0
THIS IS THE 1ST ORDER FOR THIS NEW DIE - PLEASE ENSURE ALL DIMENSIONS ARE WITHIN TOLERANCES. PLEASE PROVIDE A 6-PART DIMENSIONAL REPORT.											
LOT/TKT DETAIL: 44010010 / 206326											
9 PC											

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

1	165	152	LB
		97.50	FT
		9	PC
TOTALS			

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert. Date	Cert. No.	Sales Order	Page
03/16/09	188632	44010	1
Cust. PO	B/L No.	Lot	Date
8219	08390020	44010010	3/16/09

Sold To	Ship To
46024	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-6-1	130" MILL 6061 T6 <i>OK H</i>	D3882-1

Gross Weight	165 LBS
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Net Qty	152 LB	9 PC	97 FT	1 PKG
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Specification	Die Desc
ASTM B221-08 <i>OK H</i>	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	299.3 / 43.4 <i>OK H</i>	272.4 / 39.5 <i>OK H</i>	12.0 <i>OK H</i>	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
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.62 .30 .27 .05 .86 .06 .007 .06 .000 .010 .02 .000 .00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc



6) D3882-1 EXTRUSION MANUFACTURED FROM: DIE # DAA-6

A	NEW ISSUE	RF	09.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. REV. A D3882 SHEET 1 OF 1 TITLE SCALE EXTRUSION NTS	
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	